



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-1

Job Sheet 200331



Part No: D3278-1

Job Qty: 60 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	60 pcs	10/15/19	10/15/19	0.00	1.73	Bandsaw - 1		19-10-15
110	HAAS 5 Axis - B4B	60 pcs	10/15/19	10/15/19	0.06	18.82	HAAS - 5 - B4B		19-10-21
120	Outsource - 5 - Machining	60 pcs	10/15/19	10/15/19			MEM001-VC		
125	Packaging 2-1 - Receive - B4B	60 pcs	10/15/19	10/15/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		



Container No: S222417



Part: D3278-1

Job No: 200331

Serial No/Batch: S222417

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/15/19

Plex 9/10/19 10:14 AM Dart.lajeunesse.marie

							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	
							Packaging 2 - 29 - B4B	
							Packaging 2 - 30 - B4B	
							Packaging 2 - 31 - B4B	
							Packaging 2 - 32 - B4B	
							Packaging 2 - 33 - B4B	
							Packaging 2 - 34 - B4B	
							Packaging 2 - 35 - B4B	
							Packaging 2 - 36 - B4B	
130	QC 6	DAS 10 9-89	Qc 8	60 pcs	10/15/19	0.00 0.00	QC 6 - 9	
							QC 6 - 68	Qc 8-49 mmml 15/11/13
							QC 6 - 61	
							QC 6 - 40	
							QC 6 - 81	
140	Handfinish - 1-1 Chemical-B4B			60 pcs	10/15/19	0.00 0.57	Handfinish - 1 - 1 - B4B	
							Handfinish - 1 - 2 - B4B	
							Handfinish - 1 - 3 - B4B	NOV 15 2019
							Handfinish - 1 - 4 - B4B	
							Handfinish - 1 - 5 - B4B	
							Handfinish - 1 - 6 - B4B	
							Handfinish - 1 - 7 - B4B	
							Handfinish - 1 - 8 - B4B	
							Handfinish - 1 - 9 - B4B	
							Handfinish - 1 - 10 - B4B	
							Handfinish - 1 - 11 - B4B	
							Handfinish - 1 - 12 - B4B	

Plex 9/10/19 10:14 AM Dart.lajeunesse.marie

				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BK 19-11-15.
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 -	

M 211886.

150 Powdercoat - 1 White GI(A)- B4B

60 pcs

10/15/19

0.00 0.45

START: 135. O.V.T: 800° FINISH 205

160 QC 3

60 pcs

10/15/19

0.00 0.00

170 Packaging 3-1 - Stock - B4B

60 pcs

10/15/19

0.00 0.00

DAS
40
DEC 11 2019
9-89DAS
74
9-89
DEC 12 2019

				B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	60 pcs	10/15/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	3-55
Part Op 100 - (Bandsaw) Cut blank: 2.00" x 1.00" x 2.550" long Descriptions: 110 - (HAAS CNC vertical machine #5) 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1 120 - (Outsource process - Machining) 125 - (Receive & Inspect for Damage & Mat'l Certs) 130 - (QC6- All purchased or subcontracted products) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 180 - (QC21- Final Inspection - Work Order Release)					

DEC 12 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	13.0200 ft (.217 ea)	100-Bandsaw - 1	5207689X 5195465X

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X02.000	13	41	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		.099
2	Support	0.359inches ± 0.005	0.364 0.354		.362
3	Support	0.609inches ± 0.010	0.619 0.599		.610
4	Support	0.250inches ± 0.010	0.260 0.240		.250
5	Support	1.480inches ± 0.005	1.485 1.475		1.480
6	Support	0.125inches ± 0.010	0.135 0.115		.126
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115		.118
8	Support	2.439inches ± 0.010	2.449 2.429		2.440
9	Support	1.980inches ± 0.010	1.990 1.970		1.978
10	Support	0.130inches ± 0.030	0.160 0.100		.130
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257		.260
12	Support	0.375inches ± 0.010	0.385 0.365		.375
13	Support	0.875inches ± 0.010	0.885 0.865		.876
14	Support	0.500inches ± 0.010	0.510 0.490		.500
15	Support	0.400inches ± 0.010	0.410 0.390		.400
16	Support	1.000inches ± 0.030	1.030 0.970		1.000
17	Support	1.720inches ± 0.010	1.730 1.710		1.720
18	Support	0.125inches ± 0.010	0.135 0.115		.125
19	Support	0.125inches ± 0.010	0.135 0.115		.125

Plex 9/10/19 10:14 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					